

AMENDMENTS TO THE CLAIMS:

This listing of claims will replace all prior versions, and listings, of claims in the present application:

LISTING OF CLAIMS:

1. (Currently Amended) A liquid-cooled casting die for continuous billet casting comprising:
a form-giving casting die body (1) having at least one broad side wall with a pouring-surface for receiving molten metal in a pouring direction, a cooling-surface in contact with a cooling bath, the pouring-surface and the cooling-surface defining a thickness, and cooling bore holes running parallel to the pouring direction and at least one of (i) running closer to the pouring surface, (ii) being configured narrower in diameter, and (iii) being spaced closer to each other in at least one portion of the die body.
2. (Currently Amended) The casting die body (1) as recited in claim 1, wherein the form-giving casting die body is made of copper or a copper alloy.
3. (Currently Amended) The casting die body (1) as recited in claim 1, further comprising a die cavity (2) defined by two broad-side walls situated opposite each other and two narrow-side walls, the narrow-side walls forming a cross-section of the die cavity.
4. (Currently Amended) The casting die body (1) as recited in claim 3, wherein the cross-section of the die cavity (2) at a first end is greater than at a second end.
5. (Currently Amended) The casting die body (1) as recited in claim 3, wherein the broad-side walls further define a funnel running from the first end to the second end and the at least one portion of the die body including sides of the funnel.
6. (Currently Amended) The casting die body (1) as recited in claim 5, wherein the at least one portion extends to cover an area that is at least 20% more than the sides of the funnel.
7. (Currently Amended) The casting die body (1) as recited in claim 5, wherein the at least one portion extends to cover an area that is 30-60% more than the sides of the funnel.
- Claims 8 to 9. (Cancelled).
10. (Currently Amended) The casting die body (1) as recited in claim 12, wherein the cooling channels (4) run deeper in the at least one portion of the die body such that the thickness separating the pouring-surface from the cooling-surface is reduced in said at least one portion of the die body.

11. (Currently Amended) The casting die body (1) as recited in claim 10, wherein the thickness is reduced by 1 to 6 mm.

12. (Currently Amended) The casting die body (1) as recited in claim 1, wherein the cooling surface comprises a plurality of cooling channels (4).

Claim 13. (Cancelled).

14. (Currently Amended) The casting die as recited in claim 12, wherein casting die includes a die cavity defined by two broad-side walls defining a funnel and the cooling channels are narrower on both sides of the funnel.

15. (Currently Amended) The casting die as recited in claim 12, wherein the cooling bore holes are arranged between the cooling channels (4).

16. (Currently Amended) A liquid-cooled casting die for continuous billet casting comprising:

a form-giving casting die body (1) having at least one broad side wall with a pouring-surface for receiving molten metal in a pouring direction, a cooling-surface in contact with a cooling bath, the pouring-surface and the cooling-surface defining a thickness, and cooling bore holes running parallel to the pouring direction and being spaced at least 20% closer to each other in at least one portion of the die body, wherein the broad-side walls define a funnel having sides, the at least one portion of the die body including the sides.

17. (New) A liquid-cooled casting die for continuous billet casting comprising:

a form-giving casting die body having at least one broad side wall with a pouring-surface for receiving molten metal in a pouring direction, a cooling-surface in contact with a cooling bath, the pouring-surface and the cooling-surface defining a thickness, and cooling bore holes running parallel to the pouring direction and running closer to the pouring surface in at least one portion of the die body.

18. (New) The casting die body as recited in claim 17, wherein the form-giving casting die body is made of copper or a copper alloy.

19. (New) The casting die body as recited in claim 17, further comprising a die cavity defined by two broad-side walls situated opposite each other and two narrow-side walls, the narrow-side walls forming a cross-section of the die cavity.

20. (New) The casting die body as recited in claim 19, wherein the cross-section of the die cavity at a first end is greater than at a second end.

21. (New) The casting die body as recited in claim 19, wherein the broad-side walls further define a funnel running from the first end to the second end and the at least one portion of the die body including sides of the funnel.
22. (New) The casting die body as recited in claim 21, wherein the at least one portion extends to cover an area that is at least 20% more than the sides of the funnel.
23. (New) The casting die body as recited in claim 21, wherein the at least one portion extends to cover an area that is 30-60% more than the sides of the funnel.
24. (New) The casting die body as recited in claim 26, wherein the cooling channels run deeper in the at least one portion of the die body such that the thickness separating the pouring-surface from the cooling-surface is reduced in said at least one portion of the die body.
25. (New) The casting die body as recited in claim 24, wherein the thickness is reduced by 1 to 6 mm.
26. (New) The casting die body as recited in claim 17, wherein the cooling surface comprises a plurality of cooling channels.
27. (New) The casting die as recited in claim 26, wherein casting die includes a die cavity defined by two broad-side walls defining a funnel and the cooling channels are narrower on both sides of the funnel.
28. (New) The casting die as recited in claim 26, wherein the cooling bore holes are arranged between the cooling channels.
29. (New) A liquid-cooled casting die for continuous billet casting comprising:
a form-giving casting die body having at least one broad side wall with a pouring-surface for receiving molten metal in a pouring direction, a cooling-surface in contact with a cooling bath, the pouring-surface and the cooling-surface defining a thickness, and cooling bore holes running parallel to the pouring direction and being configured narrower in diameter in at least one portion of the die body.
30. (New) The casting die body as recited in claim 29, wherein the form-giving casting die body is made of copper or a copper alloy.
31. (New) The casting die body as recited in claim 29, further comprising a die cavity defined by two broad-side walls situated opposite each other and two narrow-side walls, the narrow-side walls forming a cross-section of the die cavity.

32. (New) The casting die body as recited in claim 31, wherein the cross-section of the die cavity at a first end is greater than at a second end.
33. (New) The casting die body as recited in claim 31, wherein the broad-side walls further define a funnel running from the first end to the second end and the at least one portion of the die body including sides of the funnel.
34. (New) The casting die body as recited in claim 33, wherein the at least one portion extends to cover an area that is at least 20% more than the sides of the funnel.
35. (New) The casting die body as recited in claim 33, wherein the at least one portion extends to cover an area that is 30-60% more than the sides of the funnel.
36. (New) The casting die body as recited in claim 38, wherein the cooling channels run deeper in the at least one portion of the die body such that the thickness separating the pouring-surface from the cooling-surface is reduced in said at least one portion of the die body.
37. (New) The casting die body as recited in claim 36, wherein the thickness is reduced by 1 to 6 mm.
38. (New) The casting die body as recited in claim 29, wherein the cooling surface comprises a plurality of cooling channels.
39. (New) The casting die as recited in claim 38, wherein casting die includes a die cavity defined by two broad-side walls defining a funnel and the cooling channels are narrower on both sides of the funnel.
40. (New) The casting die as recited in claim 38, wherein the cooling bore holes are arranged between the cooling channels.
41. (New) A liquid-cooled casting die for continuous billet casting comprising:
a form-giving casting die body having at least one broad side wall with a pouring-surface for receiving molten metal in a pouring direction, a cooling-surface in contact with a cooling bath, the pouring-surface and the cooling-surface defining a thickness, and cooling bore holes running parallel to the pouring direction and being spaced closer to each other in at least one portion of the die body.
42. (New) The casting die body as recited in claim 41, wherein the form-giving casting die body is made of copper or a copper alloy.

43. (New) The casting die body as recited in claim 41, further comprising a die cavity defined by two broad-side walls situated opposite each other and two narrow-side walls, the narrow-side walls forming a cross-section of the die cavity.
44. (New) The casting die body as recited in claim 43, wherein the cross-section of the die cavity at a first end is greater than at a second end.
45. (New) The casting die body as recited in claim 43, wherein the broad-side walls further define a funnel running from the first end to the second end and the at least one portion of the die body including sides of the funnel.
46. (New) The casting die body as recited in claim 45, wherein the at least one portion extends to cover an area that is at least 20% more than the sides of the funnel.
47. (New) The casting die body as recited in claim 45, wherein the at least one portion extends to cover an area that is 30-60% more than the sides of the funnel.
48. (New) The casting die body as recited in claim 50, wherein the cooling channels run deeper in the at least one portion of the die body such that the thickness separating the pouring-surface from the cooling-surface is reduced in said at least one portion of the die body.
49. (New) The casting die body as recited in claim 48, wherein the thickness is reduced by 1 to 6 mm.
50. (New) The casting die body as recited in claim 41, wherein the cooling surface comprises a plurality of cooling channels.
51. (New) The casting die as recited in claim 50, wherein casting die includes a die cavity defined by two broad-side walls defining a funnel and the cooling channels are narrower on both sides of the funnel.
52. (New) The casting die as recited in claim 50, wherein the cooling bore holes are arranged between the cooling channels.